

Work Order ID 151366

Friday, September 23, 2016 2:48:47 PM

151366

Page 1

Item ID: D2374 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Stud
Start Date: 9/19/2016 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: SEP 26 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr**Revision Nbr**

D2374

Rev A

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.24

Doosan Lathe

1- Turn as per Folio FA156 Rev AA & Dwg D2374 Rev: A 2- Mill
as per Folio FA156 Rev: _____ & Dwg D2374 Rev: _____ 3-Deburr per
dwg D2374

16 0 16-10-12

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.03

Quality Control

16 0 16-10-12

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.05

Quality Control

16 0 DAS 14 9-89 16/10/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 151366

Friday, September 23, 2016 2:48:47 PM

151366

Page 2

Item ID: D2374

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stud

Start Date: 9/19/2016 Start Qty: 16.00

16

Cust Item ID:

Required Date: 9/23/2016 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: St 000

0.00

130

Packaging

Memo

0.03

Packaging

1p

DAS

6

9-89

OCT 1 7 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.27

Quality Control

DAS

21

9-89

OCT 1 3 2016

DAS

21

9-89

OCT 1 2 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
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OTHER : ☐					

Picklist Print

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Page 1 / 1

Work Order ID: 151366

151366

Parent Item: D2374

D2374

Parent Item Name: Stud

Start Date: 9/19/2016

Required Date: 9/23/2016

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP D03.04.04Reformat; Made on CobraKJ/RF
IPP Rev:E Now on Doosan Lathe 08-05-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR1.000		Purchased		No		100	f	23.1700	0.1271	2.140632			

MDFI RINR1 000

Delrin Round Bar 1" color: black

Location

Loc Qty

Loc Code

MAT039

23.169974

m135214

8.629974

m135422

14.54

2.2971

P 16-10-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

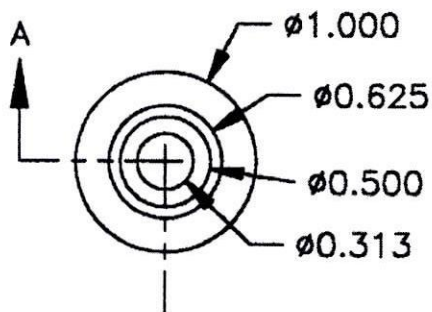
QA Closed: _____ Date: _____

Work Order update only ☐

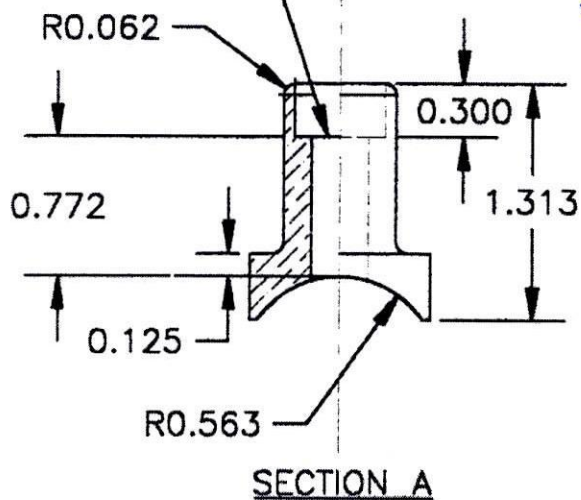
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. A
CHECKED Bw	APPROVED	D2374	SHEET 1 OF 1
DATE 95:02:24		TITLE STUD	SCALE 1:1



COUNTER BORE
Ø0.500 X 0.300 DEEP
Ø0.313 THROUGH



SHOP COPY
RETURN TO
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4/15